

Date: Tuesday, 13/01/2009 8:52:10 AM
 User: Linda Lacelle

Process Sheet

split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : JACK
 Job Number : 43352-2
 Estimate Number : 10527
 P.O. Number :
 This Issue : 13/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 12/11/2008 Type : LARGE FAB ASSY
 Previous Run : 37786
 Part Number : D33361
 Drawing Number : D3336 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 28/11/2008 Qty: 12 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est. A05.01.13 New issue KJ/JLM
 Est. A05.12.13 Added paint EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 7571

C20811113

For D3336-1 Jack P/N: 76508

Possible Supplier: Auto PartsProduct Specification sheet is required

2.0 76508 JACK



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s).
 JACK

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and Inspect for transit damage

Ensure Product Specification sheet is attached

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Drill base of jack using DT8761 as per Dwg D3336

HC 12 → 2 → M16529 (Pcs)

2-Check ram length, then tack weld as per Dwg D3336

3-Drill and Tap ram as per Dwg D3336

- 2 X JACKS REQUIRE REWORK
 PER ATTACHED EMAIL FROM ROBERTO,
 CUT BOLT HEAD, WELD BOLT STRAIGHT
 ONTO TOP OF JACK

Cpl 09.01.15

2x

Date: Wednesday, 12/11/2008 1:37:11 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK

Job Number: 43352

Part Number: D33361

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Paint base cuts to match color per dwg D3336

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.1 09.01.15 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

02/01/16 (12)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Stores

Ppl 09.01.15

09.01.15

(2)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/01/21 (1)

Job Completion



U 09.01.10

L Lacelle

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: January 7, 2009 12:27 PM
To: 'L Lacelle'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

It is ok with me, if that produce scraps the way it is now, also I check with the guys here at Eagle and said it is fine with them. Only concern with me is make sure the bolt is weld straight with shaft and have good solid weld between cap of the jack and bolt and the thread shown after nut be max. 1/4" and may be add a lock washer. This will required to update assembly drawing.

Roberto

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 07, 2009 7:44 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; bbeckett@dartaero.com
Subject: RE: Hydraulic grd handling

Forgot to include attachment... sorry

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 7, 2009 9:42 AM
To: 'Roberto Fuentes'
Cc: 'Mike Petsche'; 'David Shepherd'; 'bbeckett@dartaero.com'
Subject: Hydraulic grd handling

Hi all,

Carl had a grwat idea, to save time and parts, please see attached.

We sometimes break the cap part of the jack, by cutting off the head of the bolt and welding it on, it would take less time and make less scrap...

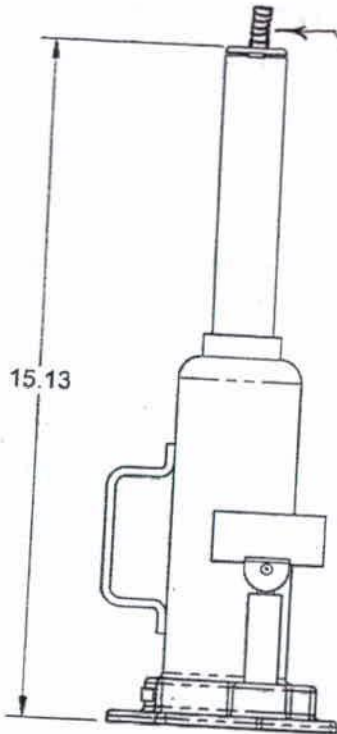
Let me know what you's think.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

07/01/2009

DART

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED RT	APPROVED [Signature]	DRAWING NO. D3336	REV. A SHEET 1 OF 1
DATE 04.12.16		TITLE JACK	SCALE 1:2
A	04.12.16	NEW ISSUE	



DETAIL A: SIDE VIEW
SCALE 1:4

1/4-20 BOLT
HC 12

CUT BOLT AND WELD
ON JACK

DRILL 0.201 x 1.00 DEEP
AND TAP 1/4-20 x 0.75 DEEP
AT CENTER OF CAP.

WELD CAP WITH SHAFT
WITH 0.375 LONG
TACKS (2 PLACES)
AROUND PERIMETER

RELEASED
05/02/09

DRILL 0.312 PER
TEMPLATE DT8761
(2 PLACES)

COUNTER BORE $\phi 0.38$
IF NECESSARY FOR
CLEARANCE OF BOLT
HEAD (2 PLACES)

TRIM EDGES AS PER
TEMPLATE DT8761
AND PAINT CUTS TO
MATCH COLOR.

D3336-1

NOTES:

- 1) MATERIAL: 8 TONS JACK. POSSIBLE SUPPLIER: AUTOPARTS
MODEL NUMBER 76508
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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C-07070

Past due accounts bear 2% interest per month (24% per annum). If this account is placed with a 3rd party collection, an administrative cost of 25% will be added. All exchanges and refund claims must be accompanied by this invoice. Electrical parts not returnable. All parts returned are subject to 20% handling charge. All merchandise sold on this invoice remains the vendor's property until this invoice is paid in full.
TERMS: Payment due on 10th day of the following month.

Aucun remboursement sans cette facture. Net 30 jours, 2% de frais d'intérêt par mois (24% par année) sur compte en souffrance. 20% de frais de manutention sur toute marchandise retournée. Clause pénale une indemnité de 25% sera chargée sur compte sujet à des procédures légales. Les marchandises mentionnées sur cette facture demeurent la propriété du vendeur tant qu'elles ne seront pas entièrement payées. Pièces électriques non-retournable.
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SIGNATURE _____

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10035 3366 RT0001

1000 RUE LANDSDOWNE HAWKESBURY, ON K6A 1H7
TEL: (613)632-1191 FAX: (613)632-2350

TVQ
1016330716 TQ0001

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TO ALL OUR CUSTOMERS, WE WISH YOU A MERRY CHRISTMAS AND A WONDERFUL YEAR

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EXP
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TO
A

113336
*** SAME ***

DATE: 12/16/08
13:00
11C MLP

00007571

ORD / COM	SHIP / EXP	CODE	PART No / PIÈCES	DESCRIPTION	LIST EACH / CHACUN	COST / COÛTANT	EXTENSION
12	12	G2S>	NOR76508 ✓ DE G2S # IN154755	BOTTLE JACK		134.00	1608.00
	12	***	SHIP VIA	PIECES / CORE TOT REGULAR	0.00		0.00
INVOICE No / FACTURE	TYPE / SORTE	TOTAL	DISC / ESC	FRT / TRANS	GST / TPS	PST / TVQ	AMT to PAY / À PAYER
1191/298	INVOICE	1688.00	0.00	0.00	80.40	0.00	1688.40

VERSUS BUSINESS FORMS (CORNWALL) (613) 936-1852